

Work Order ID 162662

Wednesday, June 07, 2017 8:14:28 AM

162662

Page 1

Item ID: D4931-3

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Engine Fitting (for B3 models)

Start Date: 6/7/2017 Start Qty: 8.00

8

Cust Item ID:

Required Date: 6/23/2017 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D4931

A

100

0.08

100

Hardinge CNC LATHE SMALL

Doosan

Memo

3.76

Doosan Lathe

Machine as per folio FB210

Folio rev: 7/1ADWG REV: A

Deburr

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.08

Quality Control

8 0 17-6-9

8 0 17-6-9

Page 2

[illegible]

DQA:

Date:

2017-07-10



QA Closed:

Date:

JUL 03 2017

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only ☐

Work Order: <u>162 662</u> Part No. <u>D 4931-3</u> NCR No. <u>17-6487</u>	DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☒</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>			Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☒	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																	
Machining ☒	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																	
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																	
Large Fab ☐	Composite ☐	Supplier ☐																		
Date: <u>17-06-13</u>	Step #: <u>112</u>	QTY Effective: <u>2</u>	MRB (QSI042) Approval <u>PD 17.06.13</u>																	
Description Work Order Deviation		Disposition																		
The 2 ϕ . 238" hole are taper (from ϕ . 250 to ϕ . 241) (Broken drill bit)		Scrap destroy no replace.																		
		DAS Completed By <u>32 J.C.C.</u> <u>9-89</u> <u>17-06-13</u> Lead hand / Supervisor Approval Verification DAS <u>08</u> <u>17-06-13</u> QC / QA Coordinator Approval <u>PD 17.06.13</u>																		
Root Cause		FAULT CATEGORY																		
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☒ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ ☒ Drill Holes	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐															
		OTHER: ☐																		

Work Order ID 162662***162662***

Page 3

Wednesday, June 07, 2017 8:14:28 AM

Item ID: D4931-3 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Engine Fitting (for B3 models)
Start Date: 6/7/2017 Start Qty: 8.00 ***8*** Cust Item ID:
Required Date: 6/23/2017 Req'd Qty: 8.00 ***8*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <i>SH38</i>	0.00							
130									
Packaging	Memo	0.08							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.80							
Quality Control									

p DAS 6 9-89
JUN 15 2017
17/6/19 *[Signature]*
DAS 21 9-89 JUN 15 2017

Picklist Print

Wednesday, June 07, 2017 8:14:26 AM

Page 1

Work Order ID: 162662

162662

Parent Item: D4931-3

D4931-3

Parent Item Name: Engine Fitting (for B3 models)

Start Date: 6/7/2017

Required Date: 6/23/2017

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP REV:A NEW ISSUE 13-09-16 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303R2.000		Purchased				100	f	24.0000	0.15	1.263158			
M303R2 000									**			6/17-6-9	
303 ROUND BAR 2"													

Location

Loc Qty

Loc Code

MAT028

24

m136463 1

12

m137481

12

1.6

DART AEROSPACE LTD		Work Order: 102662
Description: EAPS P2 Engine Fitting		Part Number: D4931-3
Inspection Dwg: D4931	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1-1/16-12 UN 2A	Maj: 1.0608 Min: 1.0494	1.058	✓			
M.O.W.	Maj: 1.0995 Min: 1.0938	1.096	✓			
0.13 x 45°	+/-0.030 x +/-0.5°	13X45°	✓			
Ø0.063	+0.004/-0.001	0.063	✓			
-0.08 0.07	+/-0.010	0.080	✓			
-0.006 0.007	+/-0.010	0.009	✓			
0.13	+/-0.030	0.127	✓			
0.25	+/-0.030	0.260	✓		Caliper	JCL-08
0.938	+/-0.010	0.948	✓			
1.927	+/-0.010	1.937	✓			
0.250	+/-0.010	0.250	✓			
0.424	+/-0.010	0.424	✓			
0.315	+/-0.010	0.315	✓			
0.185	+/-0.010	0.185	✓			
37°	+/-0.5°	37°	✓			
0.33 0.34	+/-0.030	0.335	✓			
-34° 35°	+/-0.5°	35°	✓			
0.532	+/-0.010	0.531	✓			
1.063	+/-0.010	1.063	✓			
0.594	+/-0.010	0.595	✓			
0.791	+/-0.010	0.792	✓			
1.188	+/-0.010	1.188	✓		Caliper	JCL-08
1.582	+/-0.010	1.585	✓			
Ø 0.394	+0.006/-0.001	0.395	✓			
Ø 0.238	+0.008/-0.005	0.239	✓			
DAS						

Measured by: JJ	Audited by: DAS	Preliminary Approval:
Date: 17-6-13	Date: 17-06-13	Date:

Rev	Date	Change	Revised by	Approved
A	14.06.24	New Issue	KJ	

